

nesday, 19/11/2008 2:17:56 PM
Dawson

Process Sheet

Job Number	: 43556A	Drawing Name	: "T" HANDLE ASSEMBLY
Estimate Number	: 11179	Part Number	: D2282041
P.O. Number	:	Drawing Number	: D2282 REV E
This Issue	: 19/11/2008 S.O. No. :	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: E
First Issue	: / / Type : SMALL /MED FAB	Material	:
Previous Run	: 43401A	Due Date	: 05/01/2009 Qty: 50 Um: Each
Written By	:		
Checked & Approved By	: <u>JUD 08.11.19</u>		
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22823	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2282-3

Handle tube

B43411 = 11x.
B4443 = 39x.

SP 09.02.25.

2.0	D22825	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2282-5

Handle tube

B45385 = 50x

SP 09.02.25

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration.as per dwg D2282

*****brush weld right after welding, to take color off *****

A/R ER316L SS

Filling Rod

M106115

Dwg Rev: E

50x

SP 09.02.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 19/11/2008 2:17:56 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 43556A

Part Number: D2282041

Job Number:



Seq. #: Machine Or Operation: Description :

4.0

QC9

VISUAL WELDING INSPECTION



P12

Comment: VISUAL WELDING INSPECTION

lpl 09.03.02

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

B 9-3-4

6.0

QC5

INSPECT WORK TO CURRENT STEP



count

Comment: INSPECT WORK TO CURRENT STEP

S 0263/04

246

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST262

SS 09/03/05 K46

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/05 HJ

Comment: FINAL INSPECTION/W/O RELEASE


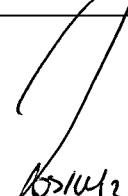
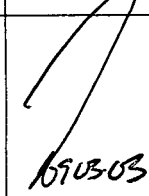

Job Completion



MF
09-03-05

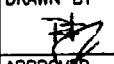

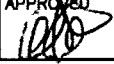
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2282-041 PAR #: N/A Fault Category: Prod / FAB. Lrg. NCR: (Yes) No DQA: D Date: 09/03/05
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/03/05

NCR: <u>43556A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/3/02	#30	1/2 parts scrap. welder ran out of gas when welding.		Scraped defective parts due to possible weld contamination.	SP 09.03.4.	S 09/03/04		
		P.C. failure to check tank before starting Sub. Homomerror.			SP 09.03.4.	S 09/03/04		

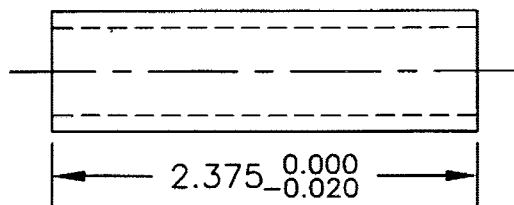
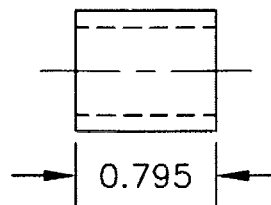
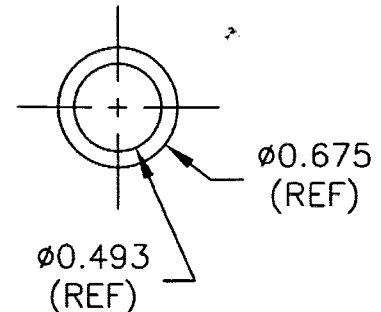
NOTE: Date & initial all entries

DART

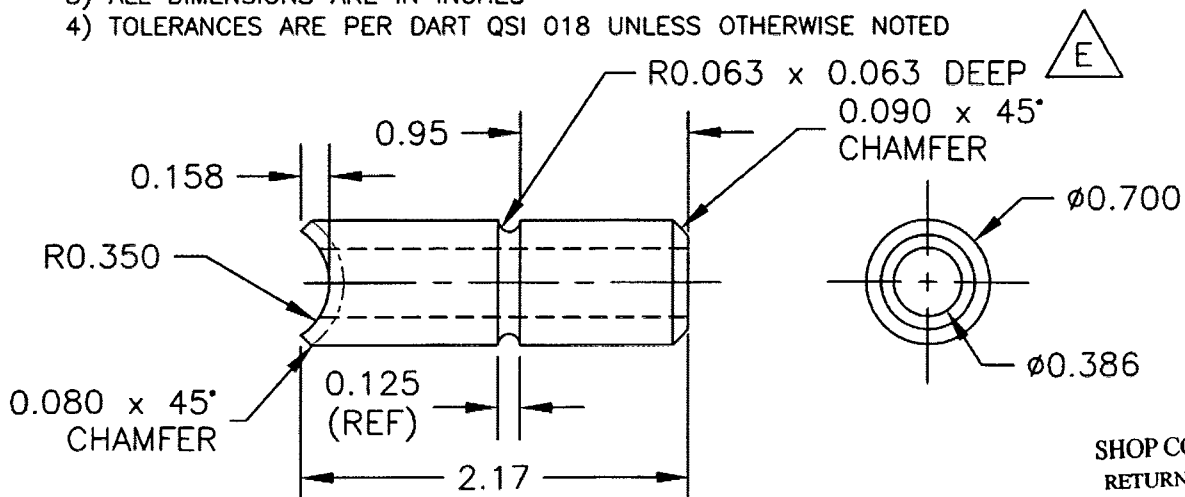
DESIGN BW	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

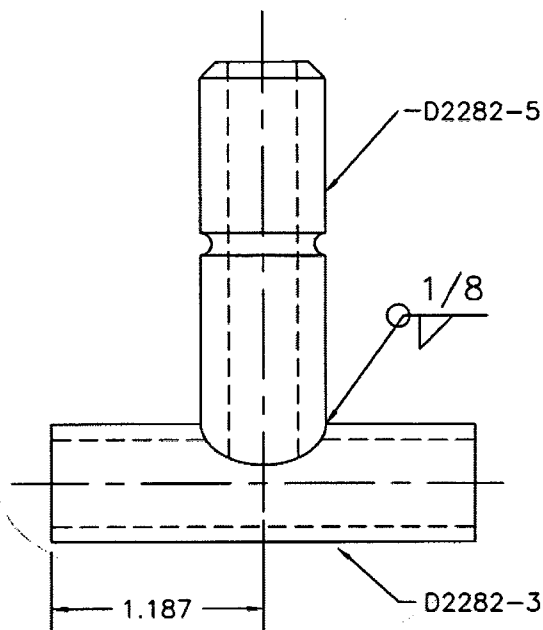
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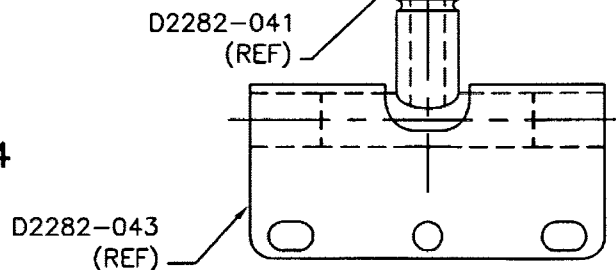
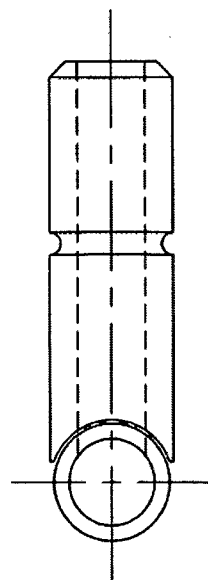
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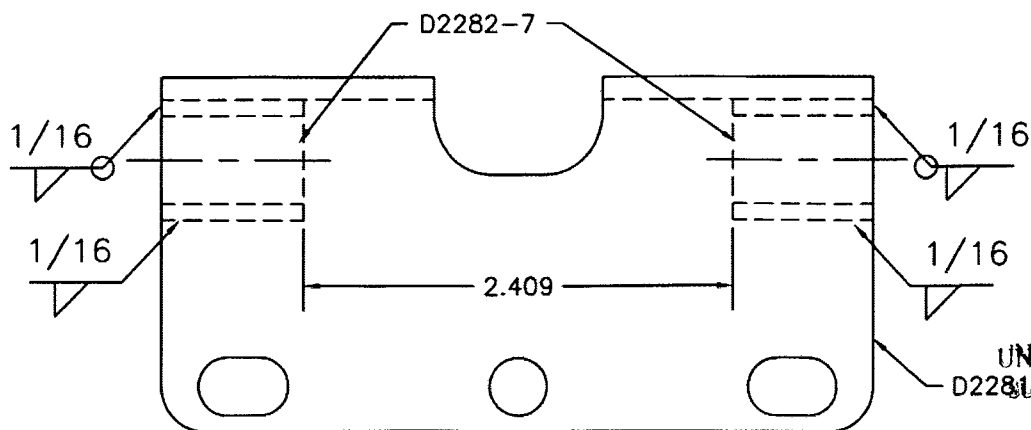
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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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